

Work Order ID 65881



Page 1

Wednesday, January 26, 2011 1:53:38 PM

Item ID: D4271-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Beam Assembly

Start Date: 1/26/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/4/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 1/26/2011

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4271

ATR Rev. B

11.01.31

100

0.00



Small Fab

Memo

0.00

Small Fab

1- Pick and Assemble as per dwg

[Signature]
1/27/11
1/22/10

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

[Signature]

[Signature]

120

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

[Signature]
11/2/10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/10

U 1002-10

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Picklist Print

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Page 1

Work Order ID: 65881

Parent Item: D4271-013

Parent Item Name: Aft Beam Assembly



Start Date: 1/26/2011

Required Date: 2/4/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 10.11.18 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4148-3 Stud Receiver, Lower		Manufactured	No			100	Each	6.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST132		6							
				63722		6							
D4148-5 Eyebolt Stud		Manufactured	No			100	Each	5.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ENG		1							
				64212		1							
				GA		4							
				61005		2							
				63450		2							
D4274-3 Plate, Aft Support		Manufactured	No			100	Each	0.0000	2	2			
D4276-1 Aft Beam		Manufactured	No			100	Each	0.0000	1	1			



63722

[Handwritten signature]



B 66225

[Handwritten signature]



65886

[Handwritten signature]



65671

[Handwritten signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Wednesday, January 26, 2011 1:53:44 PM

Page 2

Work Order ID: 65881

Parent Item: D4271-013

Parent Item Name: Aft Beam Assembly

Start Date: 1/26/2011

Required Date: 2/4/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C12A

Purchased

No

100

Each

88.0000

8

8



Bolts

Location

Loc Qty

Loc Code

ST351

88

112314

8

114761

11

116022

2

116289

17

116428

50

MS20615-4M18

Purchased

No

100

Each

341.0000

8

8



Rivet

Location

Loc Qty

Loc Code

ST323

341

114808

152

115037

189

MS21043-3

Purchased

No

100

Each

1,620.000

8

8



Nut

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

1544

112314

1544

Wednesday, January 26, 2011 1:53:45 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 3

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Parent Item: D4271-013

Parent Item Name: Aft Beam Assembly

Start Date: 1/26/2011

Required Date: 2/4/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

100

Each

4,636.000

16

16



Washer

[Signature]

Location

Loc Qty

Loc Code

ST297

4636

115000

125

115698

35

116025

1476

116304

3000

116025

perm. chg. *11.02.07* AN4C13A qty 2 B# M116191 * *EP 11/02/10*

MS21043-4 qty 2 B# M115936 * *EP 11/02/10*

NAS1149C0432R qty 4 B# M116805 * *EP 11/02/10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

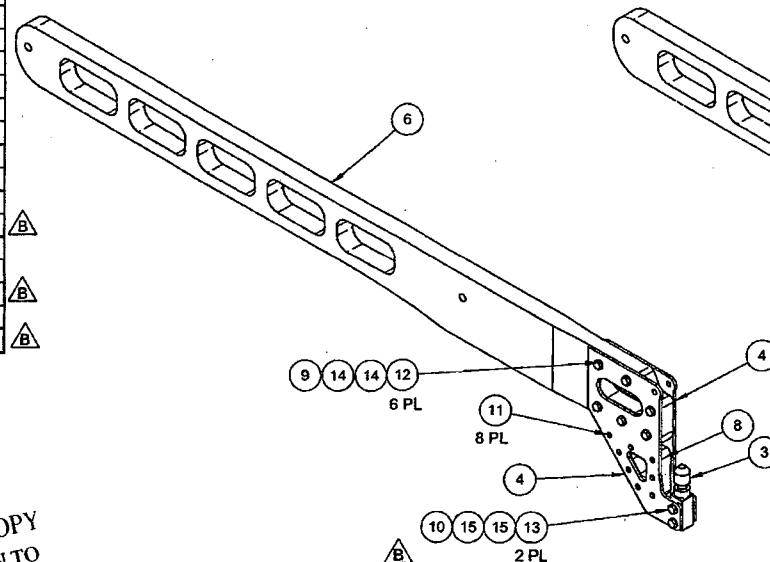
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

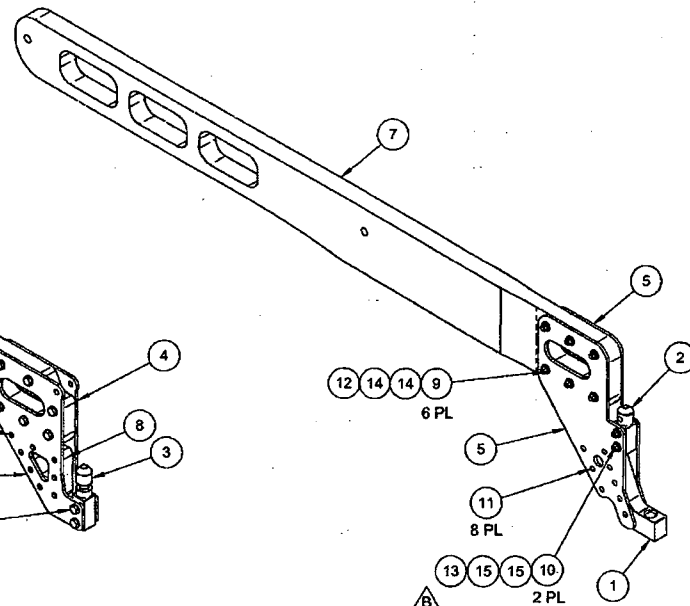
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ITEM	QTY -011	QTY -013	PART NUMBER	DESCRIPTION
			D4271-011	FWD BEAM ASSY
			D4271-013	AFT BEAM ASSY
1		1	D4148-3	STUD RECEIVER
2		1	D4148-5	EYEBOLT STUD
3	1		D4149-5	EYEBOLT STUD
4	2		D4274-1	PLATE, FWD SUPPORT
5		2	D4274-3	PLATE, AFT SUPPORT
6	1		D4275-1	FWD BEAM
7		1	D4276-1	AFT BEAM
8	1		D4281-1	SPACER
9	6	6	AN3C12A	BOLT
10	2	2	AN4C13A	BOLT
11	8	8	MS20615-4M18	RIVET
12	6	6	MS21043-3	NUT
13	2	2	MS21043-4	NUT
14	12	12	NAS1149C0332R	WASHER
15	4	4	NAS1149C0432R	WASHER



D4271-011 FWD BEAM ASSEMBLY



D4271-013 AFT BEAM ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65881

2011-01-26

RELEASED
2010-12-06

B	ITEM 10 CHANGED FROM AN3C12A TO AN4C13A	SC	10.12.01
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH		
DRAWN	SC		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.01		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4271 TITLE SUPPORT BEAM ASSEMBLIES REV. B SHEET 1 OF 2 SCALE NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

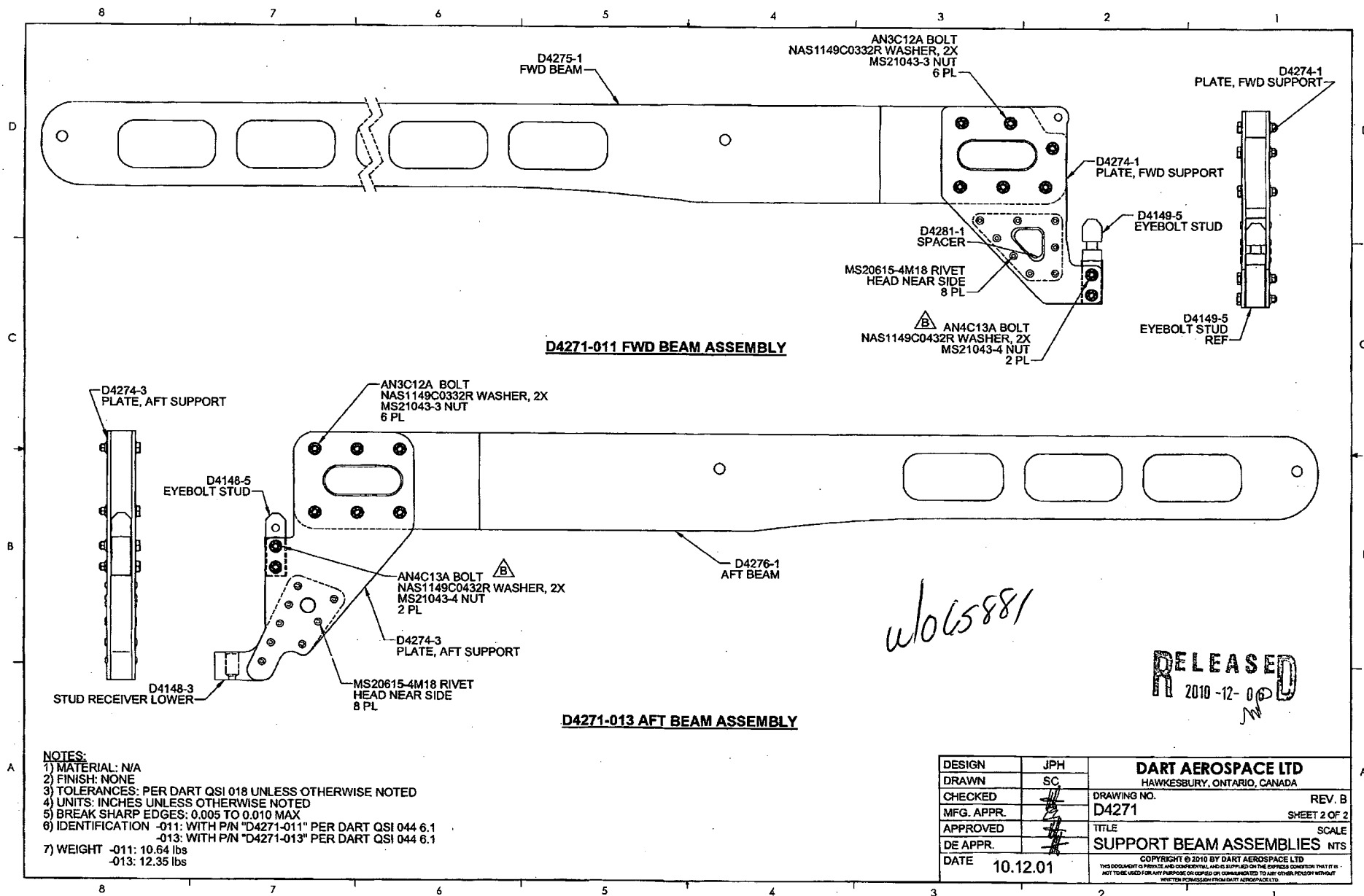
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